

Date: Tuesday, 11/29/2005 2:55:46 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CLAMP
<b>Job Number</b> : 25015	
<b>Estimate Number</b> : 10267	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2438
<b>This Issue</b> : 11/29/2005 S.O. No. : N/A	<b>Drawing Number</b> : D2438 REV. C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 23818	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 12/18/2005
<b>Checked &amp; Approved By</b> : SEE COMMENT BELOW	<b>Qty:</b> 197 <sup>200</sup> <b>Um:</b> Each
<b>Comment</b> : Est: E 05.06.28 Bending removed KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O:

Laser cut as per Dwg D2438

Material release note is required

2.0	D2438B	Clamp
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)  
 CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438

(6.786" center to center)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Tumble &amp; Deburr any rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/27

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/29/2005 2:55:46 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 25015

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/01/22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 178

06/1/26 (197)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/27

(197)

06/01/27 (197)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	4	OUR JOB NO	J0136343	SHIPPING MEMO	0327631	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
---	200 PCS	PO00000183	D2438	C	CLAMP	C
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
S.S.T 304		SAMUEL SPECIALTY/ AK STEEL		7341615 ATT'D		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 JANUARY 2006

G.F.I. Q.C. REP.

*Salman H. Al-Sel*  
46-01-05



Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2000 AS9100

### LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: 1 AOÛT 2005

**Company Name:** G.F.I. Division of Thomas & Betts limited  
**Address:** 180 avenue Labrosse  
**City:** Pointe Claire, Qué.  
**Zip Code:** H9R 1A1

**# du client:** 0066654

**# de commande SSMQ:** 843000

**Customer's order #:**

**SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	10	.060" X 48" X 96"	304 2B		7341615

Bien à vous,  
Yours truly,

*Jani Raymond*

Commis à l'administration.  
Administration Clerk.



PAGE 1/3 RIGHT FAX



**AK Steel Corporation**  
**Metallurgical Test Report**  
**Rockport Works**  
**Rockport, IN 47635**

Page 1

Load No. 7288793  
 SRN No. 7288793

CUSTOMER

SAMUEL & FILS & CIE LTEE (S)  
 PUR DEPT  
 2225 FRANCIS HUGHES DRIVE  
 LAVAL, CN H7S1N-5

SHIP TO

SAMUEL & FILS (QUEBEC) LTEE  
 2225 FRANCIS HUGHES  
 LAVAL, CN H7S1N-5

MILL ORDER NO.  
 252502-0523

PROCESSOR ORDER NO.  
 C97428-1

BUYERS ORDER NO.  
 C97428-1

PART NO.

COIL ID	HEAT	PARENT COIL ID	WEIGHT	ENGLISH UNITS	PRODUCT SIZE	METRIC UNITS
583431-05BA	7341615	0583431-05B	13,140 LBS. 5,960 KG.	.0590 NOM	48.0000 X COIL	
503431-05BB	7341615	0503431-05B	13,050 LBS. 5,919 KG.	.0590 NOM	48.0000 X COIL	
503431-05BC	7341615	0503431-05B	13,130 LBS. 5,956 KG.	.0590 NOM	48.0000 X COIL	

L-Ladle Analysis of Heat

P-Product Analysis of Parent Coil

**CHEMICAL ANALYSIS**

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7341615	.052	1.385	.032	.0011	.342	18.18	8.10	.35	.0390	.37						

SHIPPING DATE: 02/16/2005

REMARKS:

NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL. MATERIAL FREE OF RADIOACTIVE ISOTOPES

**PRODUCT DESCRIPTION**

CR SHT TYPE 304 STAINLESS #2B FINISH SLIT EDGE TEST REPORTS \* ASTM A 240 -04 EX PARA 3.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 \* ASTM A 480 -01 EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY \* ASTM E SA-240 SECTION II PART A (2001 ED, 2002 ADDENDA) EX PARA 3.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 \* ASME SA-480 SECTION II PART A (2001 ED) EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY \* ASTM A 262 -01 PRACTICE E \* ASTM A 666 -00 EX 6.1.9 ELONG WILL BE DETERMINED BY ASTM E 8, EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVERSE TEST DIRECTION IN ALL CASES

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. 2% OFFSET (KSI)	ROCKWELL HARDNESS TALL	ROCKWELL HARDNESS FRONT			
0583431-05B	T	T	A.S.T.M	58.2	94.7	47.1	B 85.3	B 85.8			

\*\*\* CONTINUED ON NEXT PAGE \*\*\*

22  
04/05/05

22 0016  
TEST  
02/13/05

PAGES:001 R=92%

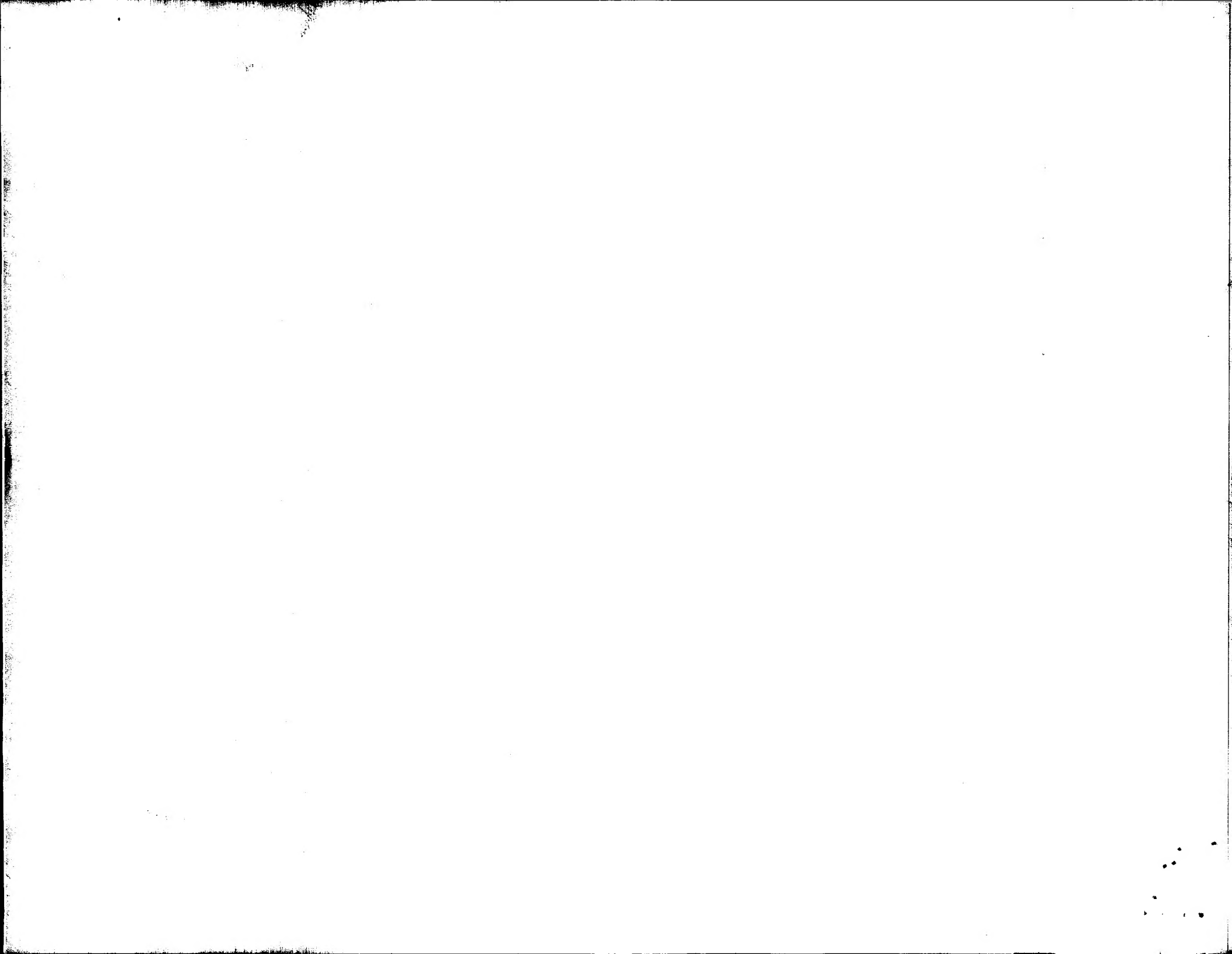
ID:SAUEL ET FILS

FAX:AK Steel RightFax



58:45 FEB-17-2005 06:45

0003/004

10/4000 LNU 11.60 FNA





		<b>AK Steel Corporation</b> <b>Metallurgical Test Report</b> <b>Rockport Works</b> <b>Rockport, IN 47635</b>		Page: 2							
				Load No. 7288793 SRN No. 7288793							
CUSTOMER SAMUEL & FILS & CIE LTEE (S) PUR DEPT 2225 FRANCIS HUGHES DRIVE LAVAL, CN H7S1N-5	SHIP Y 0	SAMUEL & FILES (QUEBEC) LTEE 2225 FRANCIS HUGHES LAVAL, CN H7S1N-5		MILL ORDER NO. 252502-0523				PROCESSOR ORDER NO. C97428-1			
				BUYERS ORDER NO. C97428-1				PART NO.			
PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	BEND 180 IT						
0583431-05B	T		A.S.T.M	PASS	OK						
[Large empty area for test results and notes]											
THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT AS CONTAINED IN THE RECORDS OF THE CORPORATION.  ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED						THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK Steel Corporation. TO AVOID THE POSSIBILITY OF ITS MISUSE ON DELIVERY OF THE REPORT TO A THIRD PARTY IT MUST BE SUBMITTED BY AND UNDER THE NAME OF SUCH CONSIGNEE					
AK Steel Corporation MWHQ/0009 3/99						SIGNED:  QUANTITY MANAGER DATE 02/17/2005 TIME 09:23 AM					